

## HipRasp

A26-200







Based on 3D-Models, the wheelpaths can automatically be generated through a meshintersector programm. On the 4 different sides of the rasp 2 sets of inclined sections are ground using a 60 or 70 degrees 1V1 wheel. In order to maintain the shape of the finishing wheel, a preroughing and pregrinding cycle is necessary.



### 1. Cycletime for production

#### Toolspecifications

Preshaped form with 0.3 mm overmeasure, no theeth

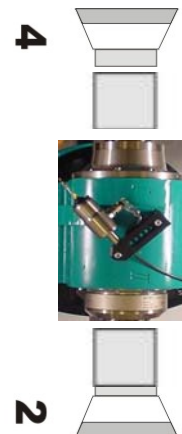
Operations			
	Profile PreRoughing	Profile Pregrind	Profile finish
Feed [mm/Min]	150	200	250
Power [kW]	1	1	1
Cutting feed [m/s]	32	32	32
Used wheels	 2	 2	 4
Grinding time [s]	2403	1796	1437
Total cycle time	93 Min 56		

The mentioned cycle times are indicative. The material to be ground, other grinding wheels and other coolants can influence the cycle times considerably.

Ø75 1V1 or 11V9  
B126

### 2. Used grinding wheels

Ø75 1V1 or  
11V9 B126



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR  
Control: Fanuc 31i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 5

responsible engineer: S. Sigrist, 19.1.07

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

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